

Work Order ID 125764

Wednesday, October 22, 2014 12:34:30 PM

125764

Page 1

Item ID: D350-578-031

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw Wearplate Installation

Start Date: 10/17/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 10/23/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: MCS Date: 11-10-22 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr | |
|----------|--------------|-------------|
| D350-578 | G | <i>keep</i> |

| | | | | | | | | | |
|-------------------------------|---|------|--|--|--|--|--|--|--|
| 100 | Document Control | 0.00 | | | | | | | |
| *100* | DOCUMENT CONTROL | | | | | | | | |
| DC | Memo | 0.00 | | | | | | | |
| Doc.Control -USB or Paperwork | Photocopy bluefile and type labels per PPP D350-578-031 CHG 002 | | | | | | | | |

DAS
06
9-89

| | | | | | | | | | |
|--------------|----------|------|--|--|--|--|--|--|--|
| 105 | Pick Kit | 0.00 | | | | | | | |
| *105* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |

DAS
26
9-89

| | | | | | | | | | |
|-----------------|---|------|--|--|--|--|--|--|--|
| 110 | QC4- 100% Inspect kits for completeness | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

DAS
06
9-89

NOV 12 2014

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|

Work Order ID 125764

Wednesday, October 22, 2014 12:34:30 PM

125764

Page 2

Item ID: D350-578-031

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw Wearplate Installation

Start Date: 10/17/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/23/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 120 | Packaging | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | Identify and pack for shipping as per PPP D350-578-031 and DSI9429 | | | | | | | | |
| | Location: <u>KG 106</u> | | | | | | | | |
| | PPP Rev: _____ | | | | | | | | |
| 130 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

DAS
06
9-89

NOV 12 2014

14/11/14

24-11-13

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
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| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
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|--|--|---|--|

Picklist Print

Wednesday, October 22, 2014 12:34:29 PM

Page 1

Work Order ID: 125764

125764

Parent Item: D350-578-031

D350-578-031

Parent Item Name: Bearpaw Wearplate Installation

Start Date: 10/17/14

Required Date: 10/23/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM
14.05.01 AS PER ECN14-544 DD VERF:JLM

IPP REV:B

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-----------------|--------------|---------------|----------------|-------------------|
| AN4-17A *AN4-17A* Bolt | | Purchased | | No | | 105 | Each | 345.0000 | 12 | 12 | | | DAS 26 9-89 |
| | | | | | <u>Location</u> | | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | |
| | | | | | ST343 | | | 345 | | | | | |
| | | | | | 124858 | | | 12 | | | | | |
| | | | | | M128813 | | | 133 | | | | | |
| | | | | | M129909 | | | 200 | | | | | |
| D3859-041 *D3859-041* Wearplate | | Manufactured | | No | | 105 | Each | 0.0000 | 2 | | | | DAS 26 9-89 |
| MS21042L4 *MS21042L4* Locknut | | Purchased | | No | | 105 | Each | 3,238.000 | 12 | 12 | | | DAS 26 9-89 |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| ST007 | 12 | |
| 121444 | 12 | |
| ST305 | 3226 | |
| 111827 | 2 | |
| 126275 | 5 | |
| m126015 | 12 | |
| m126275 | 27 | |
| m127255 | 63 | |
| m127376 | 12 | |
| m127813 | 741 | |
| m128300 | 69 | |
| m128798 | 658 | |
| m129472 | 137 | |
| m129934 | 1500 | |

NOV 12 2014

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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|--|--|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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| Offset/Setup | | | | | | | | | |
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| Training | | | | | | | | | |
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|--|--|---|--|

5.0 PARTS LIST

| Qty -011 | Qty -013 | Qty -015 | Qty -017 | Qty -021 | Qty -031 | Part Number | Description |
|-------------|-------------|-------------|-------------|-------------|-------------|---------------|----------------------|
| X | | | | | | D350-578-011 | BEARPAW INSTALLATION |
| | X | | | | | D350-578-013 | BEARPAW INSTALLATION |
| | | X | | | | D350-578-015 | BEARPAW INSTALLATION |
| | | | X | | | D350-578-017 | BEARPAW INSTALLATION |
| | | | | X | | D350-578-021 | BEARPAW INSTALLATION |
| | | | | | X | D350-578-031 | WEARPLATE KIT |
| 6 | 6 | | | 6 | | D2182B050 | Rubber Cushion |
| 12 | 12 | 12 | 12 | 12 | | D2274 | Radius Block |
| 12 | 12 | 12 | 12 | 12 | | D2529 | Washer |
| 6 | 6 | | | 6 | | D2438 | Clamp |
| 2 | | | | | | D2432F | Bearpaw |
| | | 2 | | | | D2432-3 | Bearpaw |
| | | | | 2 | | D2672F | Bearpaw |
| | | | | | 2 | D3859-041 | Wearplate |
| | | 6 | 6 | | | D4011-1 | Clamp |
| | | 6 | 6 | | | D4012-1 | Cushion |
| | 2 | | | | | D4297-1 | Bearpaw |
| | | | 2 | | | D4297-3 | Bearpaw |
| 12 | 12 | | | 12 | 12 | AN4-17A | Bolt |
| | 12 | 12 | 12 | | | AN4-20A | Bolt |
| 24 | 12 | 12 | 12 | 24 | 12 | NAS1149D0463J | Washer |
| 12 | 12 | 12 | 12 | 12 | 12 | MS21042L4 | Nut (or MS21042-4) |

Work Order ID 125764

125764

Page 1

Wednesday, October 22, 2014 12:34:30 PM

Item ID: D350-578-031

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw Wearplate Installation

Start Date: 10/17/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 10/23/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 11-10-22

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D350-578 | G |

help

100 Document Control 0.00

100

DC Memo 0.00

Doc.Control -USB or Paperwork Photocopy bluefile and type labels per PPP D350-578-031 CHG 002

MLS 11-11-12

105 Pick Kit 0.00

105

Packaging Memo 0.00

Packaging

110 QC4- 100% Inspect kits for completeness 0.00

110

QC Memo 0.00

Quality Control